

304 1-25

Work Order ID 73622

Wednesday, September 07, 2011 2:38:58 PM



Page 1

Item ID: D3453-3**Accept****Setup Start****Revision ID:****Item Name:** Clevis**Stop****Start Date:** 9/7/2011 **Start Qty:** 8.00**Cust Item ID:****Required Date:** 9/21/2011 **Req'd Qty:** 8.00**Customer:****Reference:****Approvals:****Process Plan:**
Date:**Tooling:****Date:****Run Start****QC:****Date:****SPC (Y/N):****Date:****Stop****Sequence ID/
Work Center ID****Operation
Description****Set Up/
Run Hours****Tool ID****Tool #****Plan
Code****Accept
Qty****Reject
Qty****Reject
Number****Insp.
Stamp****Draw Nbr****Revision Nbr**

D3453

Rev B

100



Doosan

Memo

1-Turn as per Folio FA578
 Rev: 1A &
 Dwg D3453 Rev: B
 2- Deburr as per dwg D3453

0.00

10/10/03

150



QC2- Inspect parts off machine FAI/FAIB

0.00

QC

Quality Control

Memo

10/10/03

160



QC8- Inspect parts - second check

0.00

QC

Quality Control

Memo

10/10/03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 73622

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Item ID: D3453-3

Accept



Setup

Start



Revision ID:

Item Name: Clevis

Stop



Start Date: 9/7/2011 Start Qty: 8.00



Cust Item ID:

Required Date: 9/21/2011 Req'd Qty: 8.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

170



Packaging

Operation
Description

Identify as per dwg & Stock Location ST-WA 0.00

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp



11-10-4

Packaging

Memo

0.00

*****STOCK IN LARGE FAB*****

180



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

MW54J

MF
11-10-4

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 73622



Parent Item: D3453-3



Parent Item Name: Clevis

Start Date: 9/7/2011

Required Date: 9/21/2011

Start Qty: 8.00

Required Qty: 8.00

Comments: A 05.09.271 (New issue) EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304R1.250 		Purchased	No			100	f	41.4400	283 0.2452	1.9616 	2.284 56	10/10/13	

304 round bar 1.250

Location	Loc Qty	Loc Code
MAT029	41.44	
105872	12.33	
108156	7.88	
111018	21.23	

~~2.5 ft total~~

~~4 notes end of bar seaf~~

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	73627
Description: Clevis	Part Number:	D3453-3
Inspection Dwg: D3453	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

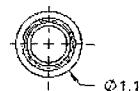
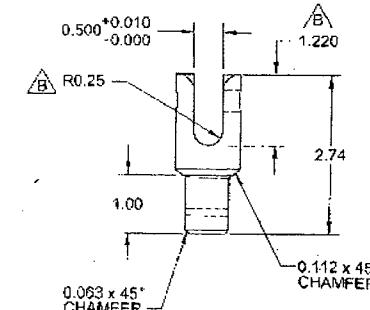
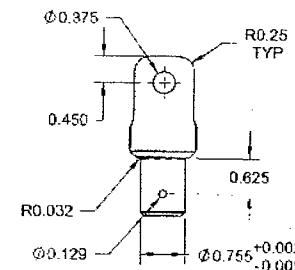
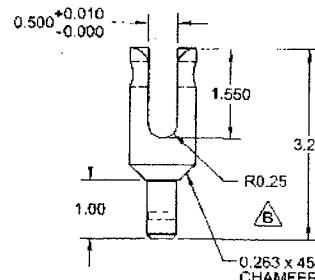
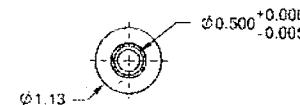
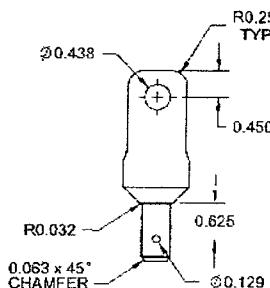
X First Article Prototype

Measured by:	S.A.
Date:	11/18/03

Audited by:	B.A.
Date:	11/10/03

Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.09.01	New Issue	KJ/JLM	
B	09.11.04	Dimensions updated per Dwg Rev B	KJ	M



D3453-1 CLEVIS

D3453-3 CLEVIS

RELEASED
09/05/21 MHD

D3453-1/-3 NOTES:

- 1) MATERIAL: AISI 304 SS ROUND BAR (REF. DART SPEC M304R)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: D3453-1 = 0.41 lbs
D3453-3 = 0.41 lbs

B	DRAWING UPDATED TO CURRENT STANDARDS; R0.25 WAS 0.050 (ZN CS-1, C2-1); 1.220 WAS 1.175 (ZN D1-1); REF PAR 04-018		RF	09.05.21
A	NEW ISSUE		RF	05.09.02
REV.	DESCRIPTION		BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	RF			
CHECKED	<i>[Signature]</i>			
MFG. APPR.	<i>[Signature]</i>			
APPROVED	<i>[Signature]</i>			
DE APPR.	<i>[Signature]</i>			
DATE	09.05.21			
DRAWING NO.	D3453			
REV.	B			
TITLE		SHEET 1 OF 2		
CLEVIS		SCALE NTS		

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